

Transmission Type... 6L80E

Rebuilder's Kwik Reference Guide



Clutch Clearances

1-2-3 Clutch060"-078" Snap Ring
4-5-6 Clutch050"-074" Snap Ring
3-5 Reverse Clutch048"-070" Snap Ring

Band Adjustment

Intermediate Band
2-4 Band
Reverse Band
Overdrive Band

Adjusted By: Torque Specifications

Pump Body to Converter Housing97	In.-Lbs.
Pump to Case53	Ft.-Lbs.
Valve Body to Halves71	In.-Lbs.
Valve Body to Case71	In.-Lbs.
Solenoid Valve Assembly to Valve Body	...71	In.-Lbs.
Pan80	In.-Lbs.
Center Support		
Case Extension37	FT.-Lbs.
Reaction Shaft Support		
Chain Cover		
Pressure Test Port Plug97	In.-Lbs.
Speed Sensor Bolts106	In.-Lbs.
Accumulator Cover to Case		
Endcover Bolts		

Unit Endplays*

Front Unit
Middle Unit
Rear Unit
Differential
Input Shaft
Output Shaft
Chain Sprocket

Location

Selective

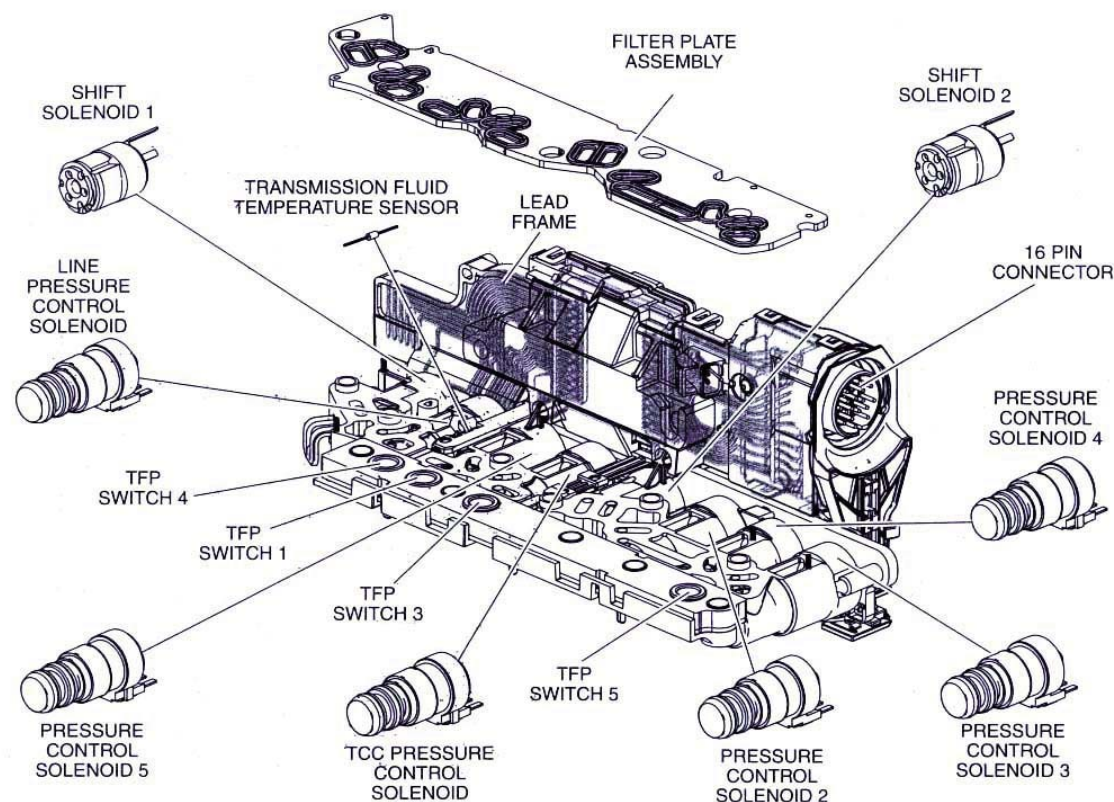
*No Specifications Not Adjustable

Transmission Type... 6L80E

Rebuilder's Kwik Reference Guide



Solenoid ID



NOTE

Solenoid Resistance Specifications Not Available.
Solenoids and TCM are Serviced as an Assembly.

Transmission Type... 6L80E

Rebuilder's Kwik Reference Guide



Solenoid Application Chart

RANGE	GEAR	SHIFT SOL 1	SHIFT SOL 2	1-2-3 CL PC SOL 5 N.L.	2-6 CL PC SOL 4 N.H.	3-5 REV CL PC SOL 2 N.H.	LOW REV 4-5-6 CL PC SOL 3 N.H.
PARK	P	ON	ON	OFF	OFF	OFF	ON
REV	R	ON	OFF	OFF	OFF	ON	ON
NEU	N	ON	ON	OFF	OFF	OFF	ON
D	1st Braking	ON	ON	ON	OFF	OFF	ON
	1st	OFF	ON	ON	OFF	OFF	OFF
	2nd	OFF	ON	ON	ON	OFF	OFF
	3rd	OFF	ON	ON	OFF	ON	OFF
	4th	OFF	ON	ON	OFF	OFF	ON
	5th	OFF	ON	OFF	OFF	ON	ON
	6th	OFF	ON	OFF	ON	OFF	ON

Note : For shift solenoids 1 and 2, "ON" = solenoid energized (Pressurized), "OFF" = solenoid de-energized (No Pressure).

Note : For Pressure control (PC) solenoids, "ON" = Pressurized, "OFF" No Pressure.

Transmission Type... 6L80E

Clutch Application Chart

Rebuilder's Kwik
Reference Guide

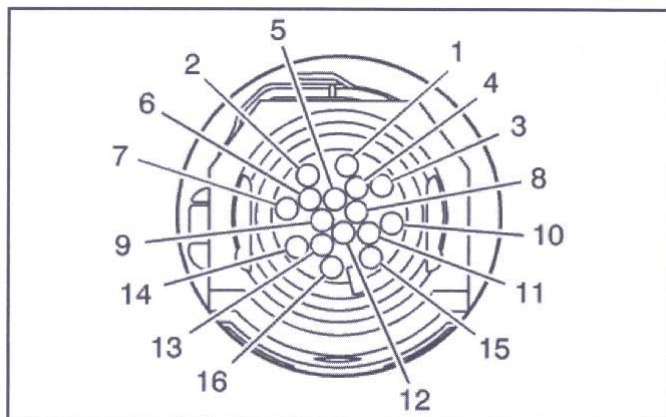


Range	Gear	1-2-3-4 CLUTCH	3-5 REV CLUTCH	4-5-6 CLUTCH	2-6 CLUTCH	LOW & REV CLUTCH	LOW CLUTCH SPRAG
<i>P</i>	<i>PARK</i>					<i>APPLIED*</i>	
<i>R</i>	<i>REV</i>		<i>APPLIED</i>			<i>APPLIED</i>	
<i>N</i>	<i>NEU</i>					<i>APPLIED*</i>	
	<i>D</i>	<i>APPLIED</i>				<i>APPLIED</i>	<i>HOLDING</i>
<i>1st</i>		<i>APPLIED</i>					<i>HOLDING</i>
<i>2nd</i>		<i>APPLIED</i>			<i>APPLIED</i>		
<i>3rd</i>		<i>APPLIED</i>	<i>APPLIED</i>				
<i>4th</i>		<i>APPLIED</i>		<i>APPLIED</i>			
<i>5th</i>			<i>APPLIED</i>	<i>APPLIED</i>			
<i>6th</i>				<i>APPLIED</i>	<i>APPLIED</i>		

* = Applied with no load.

Transmission Type... 6L80E

Rebuilder's Kwik Reference Guide



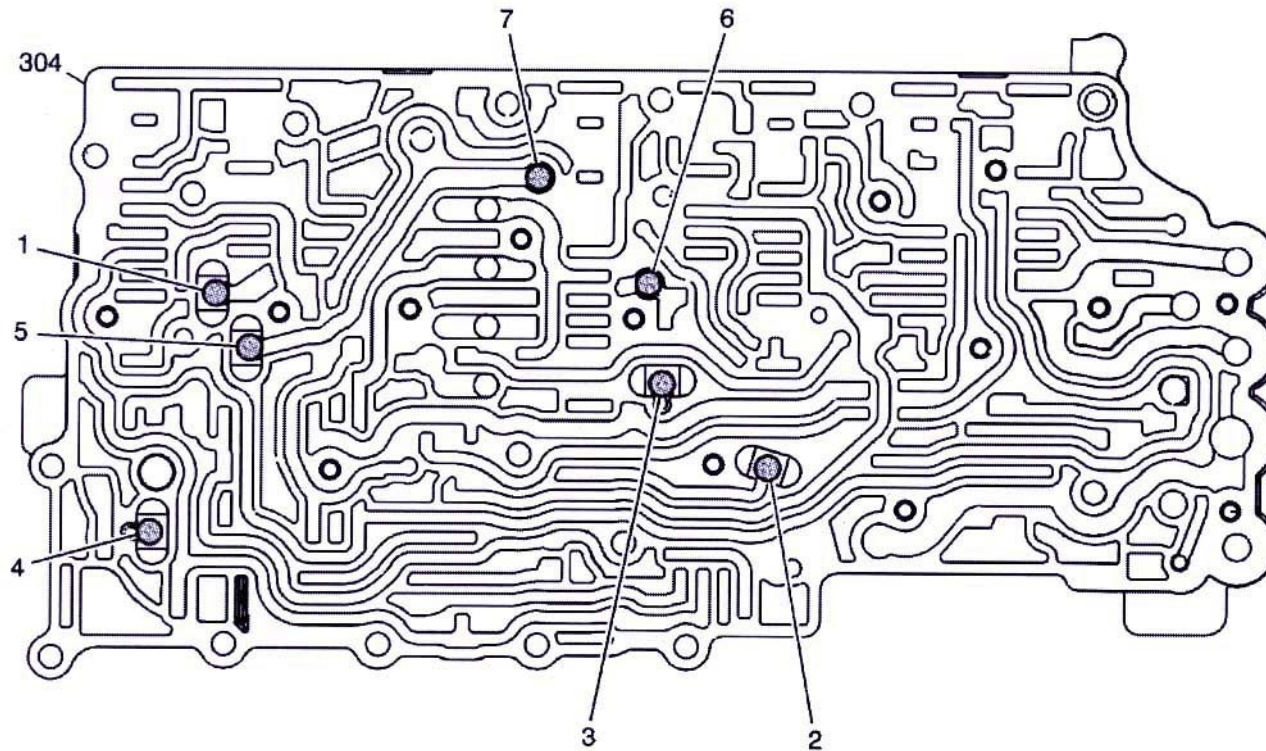
16-Way Transmission Pass-Through			
Pin	Wire Color	Circuit No.	Function
1-2	-	-	Not used
3	OG/BK	1789	Park/Neutral Signal
4	RD/WH	2440	Battery Positive Voltage
5	BK/WH	451	Ground
6	WH	17	Brake Pedal Apply Signal
7-8	-	-	Not Used
9	YE	43	Accessory Voltage Power
10	TN/BK	2500	CAN Hi
11	TN	2501	CAN Lo
12	PK	1339	Run/Crank Voltage
13	TN	2501	CAN Lo 2
14	TN/BK	2500	CAN Hi 2
15-16	-	-	Not Used

Transmission Type... 6L80E

Rebuilder's Kwik
Reference Guide



Check Ball Locations

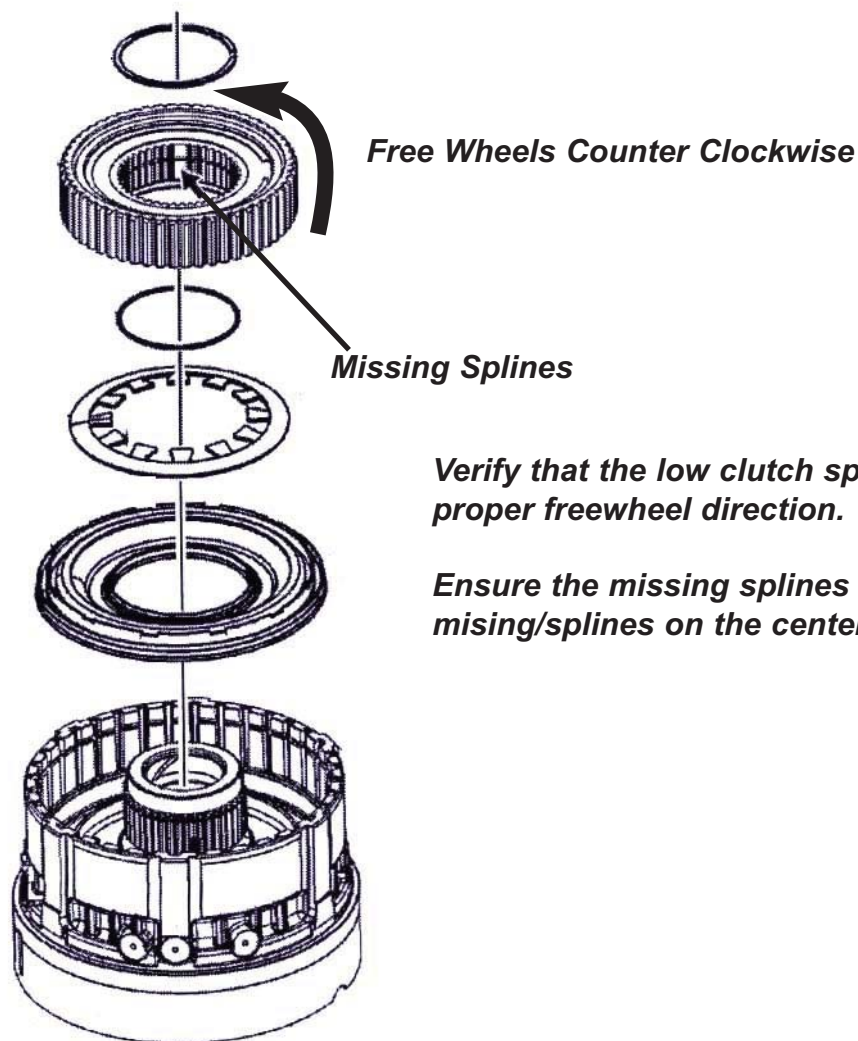


Transmission Type... 6L80E

Rebuilder's Kwik
Reference Guide



Sprag Rotation



Verify that the low clutch sprag is operating correctly. Refer to the illustration for proper freewheel direction.

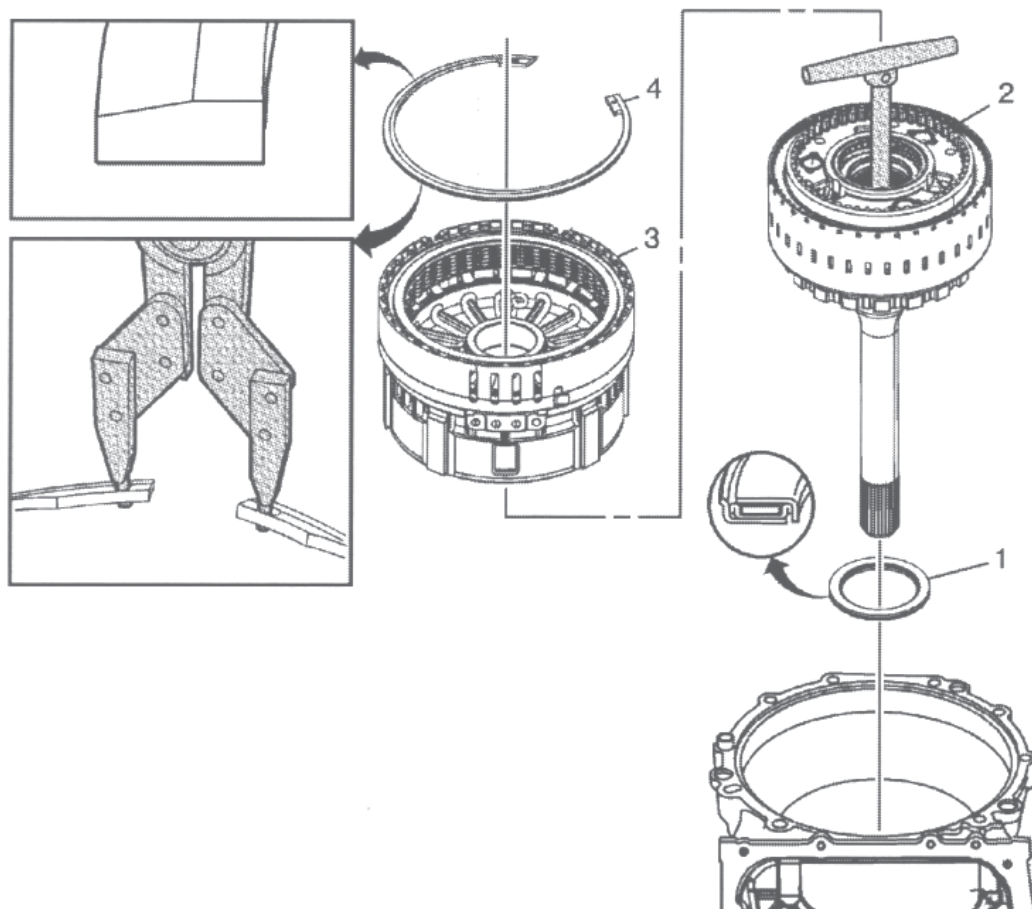
Ensure the missing splines on the sprag assembly are aligned with the missing/splines on the center support hub.

Transmission Type... 6L80E

Rebuilder's Kwik Reference Guide



Technical Tips for Rebuilding This Unit



Install Center Support Snap Ring with the tapered side facing up and the opening at the 9 o'clock position from the pan side of the case.